



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3261-1
Job Sheet 171091



Part No: D3261-1

Job Qty: 4 ea

Part Name: Battery Case Tray



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/28/18

Job Tracking No:

Due Date: 2/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A2 IPP B 04.12.02 Material no longer cut in-house KJ/JLM IPP Rev:C 08-11-21 Material cut On Waterjet JLM Verified BY:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	2/1/18	2/1/18	0.00	0.00	Start Up Waterjet		SC 18/01/30
100	Waterjet	4 pcs	2/1/18	2/1/18	0.00	0.83	Waterjet1		SC 18/01/30
110	CNC Vertical Machining	4 pcs	2/2/18	2/2/18	1.43	6.45	HAAS1-3		m.m.v 18/02/18
120	QC	4 pcs	2/2/18	2/2/18	0.00	0.00	QC2 Machining-2		
130	QC	4 pcs	2/2/18	2/2/18	0.00	0.00	QC8 Machining-2		M.A 18-02-02
140	Packaging	4 pcs	2/2/18	2/2/18	0.00	0.00	Packaging3		SJL
150	QC21-SA	4 Ea	2/2/18	2/2/18	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB750	UHMW .750 sheet	7.6000 sf (1.9 ea)	90-Start up Operation	

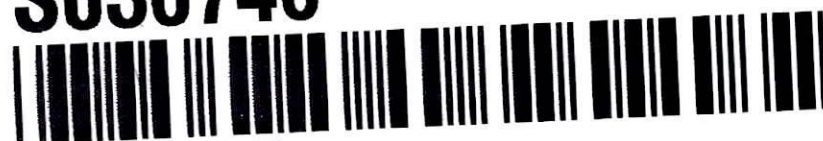
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB750	8	18	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S036746



Battery Case Tray

PART NO: D3261 - 1
Original Serial #: S036746
Revision:
Operation:
Change No:

Start up Operation

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

01/30/18

Job No: 171091

DART AEROSPACE LTD		Work Order:	171061
Description: Battery Case Tray (Dual Battery Rack)		Part Number:	D3261-1
Inspection Dwg: D3261 Rev: A2		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
22.00	+/-0.030	22.00	✓			
18.00	+/-0.005	18.00	✓		TAPE	
12.25	+/-0.030	12.25	✓			
9.75	+/-0.030	9.75	✓		TAPE	
1.27	+/-0.030	1.28	✓		Ver	
11.00	+/-0.030	11.00	✓		TAPE	
Ø0.191	+0.005/-0.001	.191	✓		G.P.	
0.50	+/-0.010	.505	✓		Ver	
0.49	+/-0.03	.49	✓		Ver	
2.00	+/-0.010	2.000	✓		Ver	
10.00	+/-0.010	10.00	✓		TAPE	
1.00	+/-0.010	1.00	✓		Ver	
2.13	+/-0.010	2.125	✓		Ver	
Ø0.386	+0.005/-0.001	.386	✓		G.P.	
4.00	+/-0.005	4.000	✓		Ver	
0.75	+/-0.030	0.754	✓			
0.125	-0.010/+0.030	.145	✓		Mic	
0.55	+/-0.030	.550	✓		Ver	
0.50	+0.000/-0.030	.490	✓		Ver	
0.67	+0.000/-0.030	.455	✓		Ver	

Measured by: SC S.K.	Audited by: B.A.	Prototype Approval:	N/A
Date: 18/01/30 18/01/31	Date: 18-02-02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	
B	04.12.06	Dimension 0.49 +/-0.010 was 0.610 +/-0.03	KJ/JLM	
C	08.11.27	0.67 dimension added	KJ/EC	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

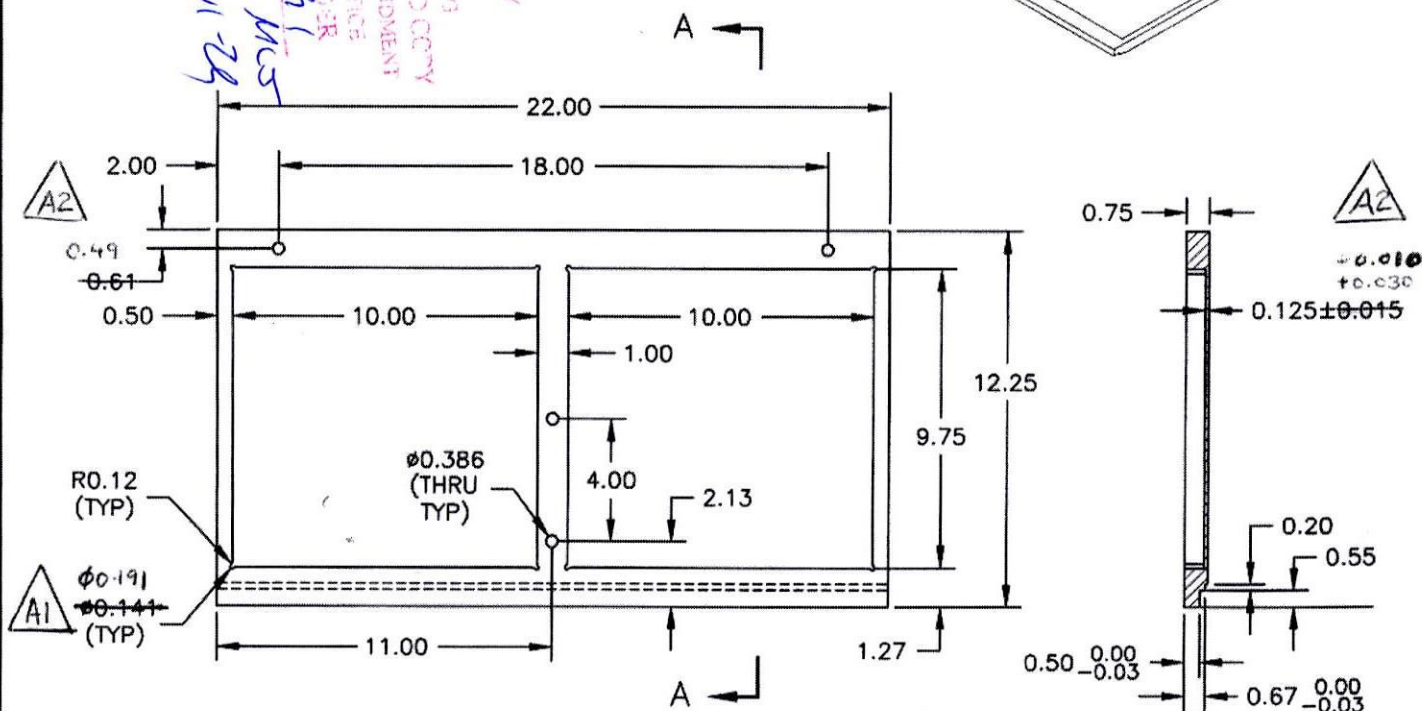
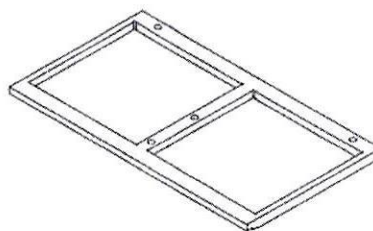
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐															
OTHER : ☐																									



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3261	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE BATTERY CASE TRAY	SCALE 1:6
A	04.04.06	NEW ISSUE	
A1	# 04.05.14	$\phi 0.191$ WAS $\phi 0.141$	
A2	# 04.06.08	$0.125^{+0.010}_{+0.030}$ WAS 0.125 ± 0.015 ; 0.49 WAS 0.61	

RELEASED
04.04.27

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WITHOUT NOTICE
WORK ORDER
NO. 171041
MCS
18-01-26



UNDER REVIEW

D3261-1

SECTION A-A

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					